



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:45 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 43808

Part Number: D26652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

09-01-07

XX

7.0 POWDER COATING

POWDER COATING



W109996

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

6

START TIME:

9:10

OVEN TEMPERATURE:

320°

FINISH TIME:

9:40

FX 09/01/07

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gf

09-01-07

XX

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



8X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 436

9/1/07

SP

10.0 QC21

FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09/01/07

MF 09-01-07

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	43808
Description: 206 Saddle, Outboard, Right side				Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.106	.112	.112	.111		
B	0.100	0.140		.117	.120	.120	.119		
C	1.125	1.145		1.135	1.139	1.136	1.136		
D	0.615	0.685		.685	.680	.680	.675		
E	0.240	0.260		.245	.249	.254	.253		
F	1.313	1.343		1.320	1.321	1.327	1.327		
G	0.210	0.230		.214	.222	.223	.223		
H	0.100	0.180		.141	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.574	1.572	1.576	1.575		
K	0.235	0.240		.236	.236	.236	.236		
L	0.100	0.120		.113	.112	.112	.112		
M	0.990	1.010		1.000	1.000	1.001	1.002		
N	0.510	0.515		.510	.511	.510	.510		
O	5.990	6.010		5.997	5.999	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.321	.321	.321	.321		
T	2.495	2.505		2.499	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.361	1.361	1.361		
V	0.787	0.807		.794	.792	.792	.794		
W	0.540	0.560		.549	.550	.549	.549		
X	1.674	1.684		1.678	1.680	1.680	1.678		
Y	0.257	0.262		.260	.260	.259	.260		
Z	0.912	0.932		.921	.922	.924	.922		
AA	0.490	0.510		.499	.499	.501	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	Onf	Audited by:	J.L
Date:	08/12/31	Date:	09/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD				Work Order:	43808
Description: 206 Saddle, Outboard, Right side				Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.111	.111	.111	.111		
B	0.100	0.140		.121	.121	.122	.121		
C	1.125	1.145		1.136	1.136	1.135	1.135		
D	0.615	0.685		.680	.680	.680	.680		
E	0.240	0.260		.253	.255	.253	.253		
F	1.313	1.343		1.327	1.327	1.326	1.326		
G	0.210	0.230		.223	.223	.223	.223		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.236	.236	.236	.236		
L	0.100	0.120		.110	.110	.110	.112		
M	0.990	1.010		1.001	1.002	1.001	1.001		
N	0.510	0.515		.510	.510	.512	.511		
O	5.990	6.010		6.000	6.000	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.321	.321	.321	.321		
T	2.495	2.505		2.499	2.499	2.500	2.500		
U	1.357	1.367		1.363	1.363	1.361	1.360		
V	0.787	0.807		.793	.794	.794	.796		
W	0.540	0.560		.549	.549	.548	.548		
X	1.674	1.684		1.680	1.680	1.677	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.922	.922	.919	.920		
AA	0.490	0.510		.502	.501	.501	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

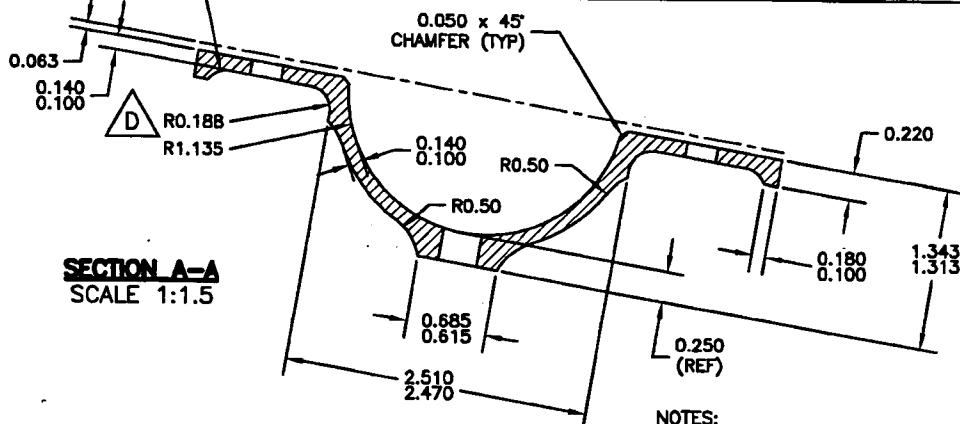
Measured by:	<i>cmf</i>	Audited by:	<i>JL</i>
Date:	09/01/02	Date:	09/01/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM <i>cmf</i>	<i>JL</i>

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2665 REV. D
PH		SHEET 1 OF 1
DATE		SCALE
06.11.08		1:3
		TITLE
		SADDLE FWD OUTSIDE HIGH

D  
R0.188



RELEASED

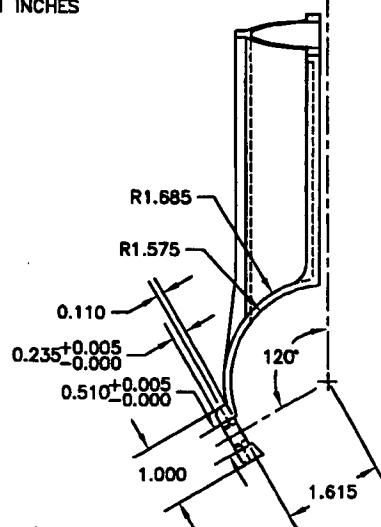
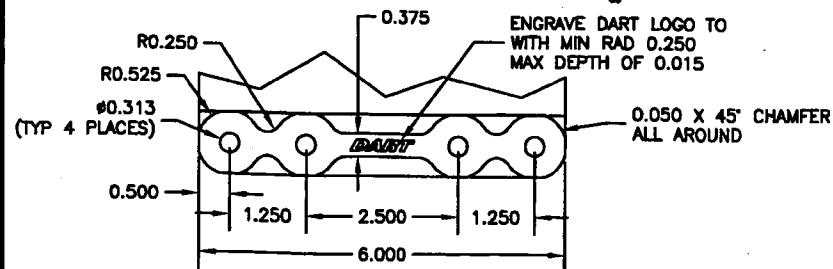
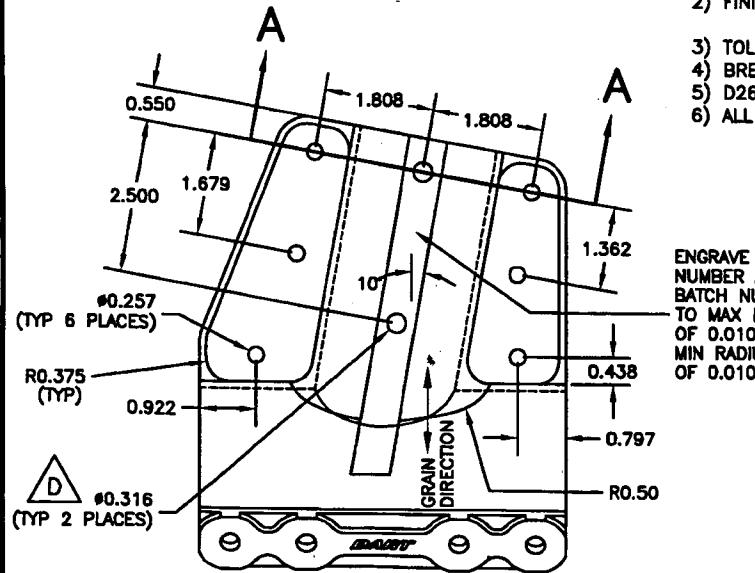
07.02.12

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43808

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



**D2665-1 SADDLE FWD OUTSIDE HIGH**

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